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(71) Applicant
Armstrong World
Industries Inc
(USA-Pennsylvania)
PO Box 3001
Lancaster
Pennsylvania 17604
United States of

America

(72) Inventor
Walter William
Chamberlain III

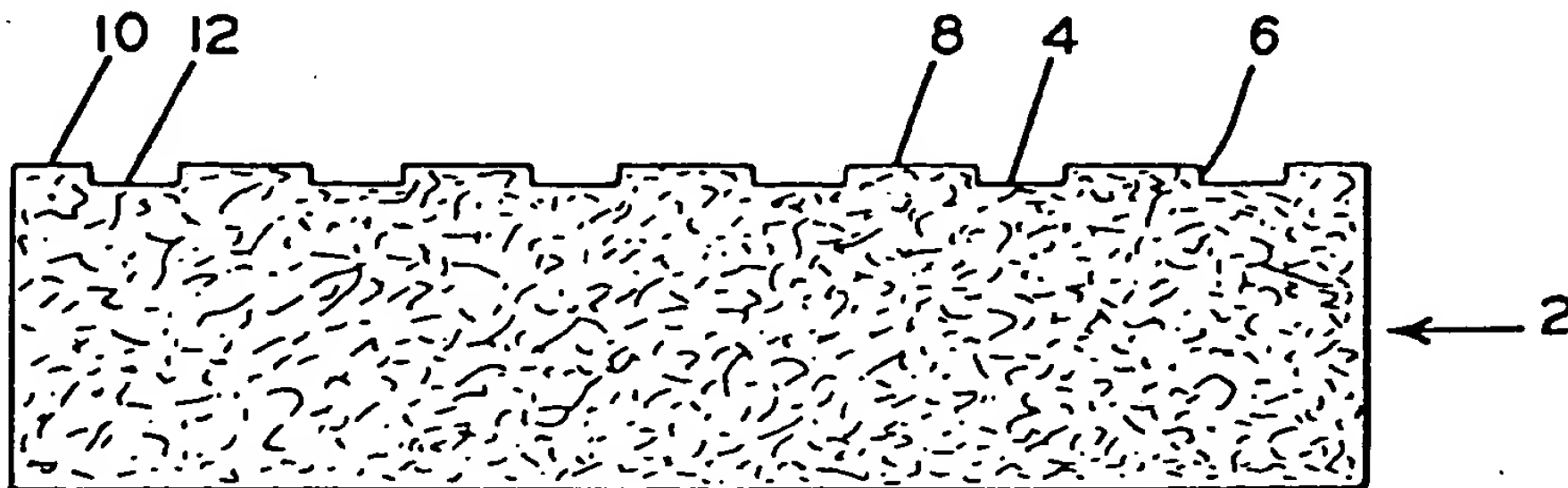
(74) Agent and/or Address for
Service

Abel and Imray
Northumberland House
303-306 High Holborn
London WC1V 7LH

needed with most mineral fibre ceiling boards to secure the desired acoustical rating.

(54) Acoustical ceiling board

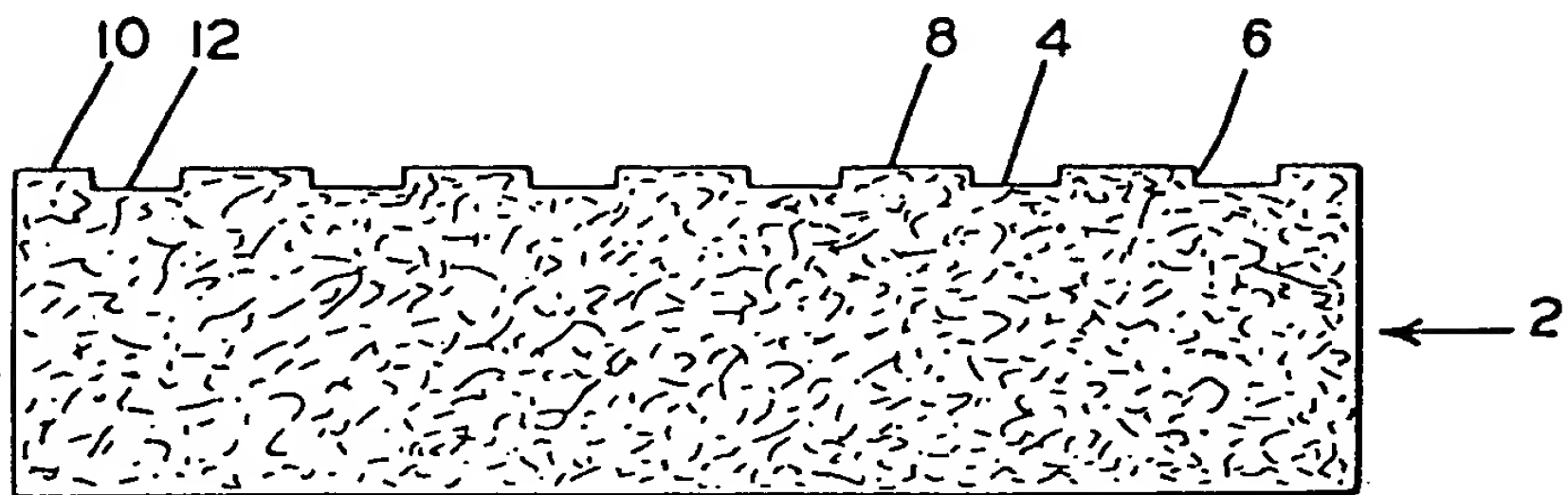
(57) An acoustical ceiling board 2 in which both the decorative appearance of the ceiling board and its acoustical properties are produced by a series of grooves 4 cut in the board surface. The porosity of the board material and the amount of vertical exposed surface 6 in the decorative pattern gives a desired acoustical rating without the pin-punched or fissured perforations



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SPECIFICATION

Acoustical ceiling board

5 The invention relates to ceiling boards and, more particularly, a ceiling board that has an acoustical property without the conventional pin punched perforations normally provided in acoustical ceiling board.

10 Ceiling panels with grooves in their face are shown in United States Design Patent No. 238,573 and in United States Design Patent No. 249,367.

In addition, United States Patent No. 3,470,977 shows an acoustical panel having short slits cut into the front face of the panel. Furthermore, it is known in the marketplace that there are a number of ceiling boards which have heavily scored surfaces. However, none of the previously proposed scored building products known to the inventor of the present invention are capable of securing a desired acoustical rating without the utilization of acoustical pin-punched perforations which tend to detract aesthetically from the decorative effect of a grooved board having plain linear geometric patterns.

The invention is directed to an acoustical ceiling board comprising a mineral fibre board structure having a porosity such that the board will have an air flow resistance of approximately 1200 cgs rays (g.cm⁻²s⁻¹) or less, according to a modified test method using the Leonard Air Flow Apparatus described in the article by R.W. Leonard appearing in The Journal of the Acoustical Society of America, Volume No. 17, page 240, 1946, so as to achieve a Noise Reduction Coefficient (NRC) rating of from 0.50 to 0.55, when tested according to American Society for Testing and Materials Standard No. ASTM C423-77, Sound Absorption of Acoustical Materials in Reverberation Rooms. A decorative pattern is placed on one surface of the board, and this pattern is a number of grooves cut in the surface of the board. The grooves are provided with side walls perpendicular to the plane of the board. The side walls of the grooves, and therefore the grooves, are of such a number and size as to provide at least about 50 square inches of side wall area per square foot of board surface (0.35 m²/m²).

One form of ceiling board constructed in accordance with the invention will now be described by way of example with reference to the accompanying drawing, the single figure of which is a cross-sectional view of the ceiling board.

Referring to the drawing, an acoustical ceiling board 2 is made of a mineral fibre structure which is approximately 3/4 of an inch (19mm) thick. On the face of the ceiling board as shown in the drawing there is provided a decorative pattern on this surface of

the board. The pattern is a number of grooves 4 cut in the surface of the board, and the grooves extend parallel to one another from one side of the board to the other. These

70 grooves 4 are formed with side walls 6 which are perpendicular to the plane 8 of the ceiling board 2. As shown in the drawing, the grooves are 1/8 of an inch (3 mm) deep and are 1/4 of an inch (6.5mm) wide and are spaced 3/8 of an inch (9.5mm) apart. The grooves in the drawing are such that the side wall area of the pattern shown is such that there is formed 50 square inches of side wall area per square foot of board surface

80 (0.35m²/m²). The ceiling board is provided with a paint coat which is normally sprayed on the ceiling board. The paint coat(s) would be applied to the raised areas 10 and the depressed areas 12 which are either in or parallel to the plane of the ceiling board.

These areas are not capable of functioning as efficient sound absorbing surfaces. The painting of the surface of the board provides these flat areas with a smooth untextured surface.

90 Since the grooves are in the ceiling board, the side walls of the ceiling board do not have a smooth surface and are somewhat open in nature, and this open structure is not plugged by the paint coat applied to the board. In

95 addition, the nature of the board is such, because it is made on a fourdrinier machine, that it has a lesser air flow resistance measured across the board and a greater air flow resistance measured through the board perpendicular to the surface 8.

The invention provides an acoustical ceiling product unique in that both the decorative appearance of the panel and its acoustical properties are produced by cutting a series of grooves in the board surface. The cutting process is called a "rilling" process wherein a series of cutters cut the grooves in the board. Whereas the surface of most conventional ceiling boards are perforated with pins or

110 fissuring dies, for acoustical purposes, the board described herein achieves its desired acoustical properties by rilling. While in many conventional ceiling products the board perforations are necessary for sound absorption and are sometimes decorative, there are certain products where the perforation detracts from the appearance. In those instances, where perforations are not desirable, the ceiling board manufacturer may try to disguise

120 the perforations by covering the board surfaces with an acoustically transparent material, such as a fabric or thin film, or by positioning the perforations so that they blend in with an embossed or printed decorative surface pattern. With the product described herein it is desired to achieve a plain linear geometric pattern on an untextured surface, and here the perforations would compete with the visual objective of the ceiling. A conventional board formulation for a ceiling product

125 130

would be as listed below.

<i>Ingredients</i>	<i>Percent by Weight</i>
mineral fibr	73-84%
5 organic fibre	5-4%
starch	7-6%
clay	15-5%

The above provides the basic ingredients of
 10 a mineral wool fibre board and the approxi-
 mate range in which these products appear.
 In many cases, the mineral fibre ingredient is
 composed of virgin mineral fibre and
 "broke", which is scrap processed ceiling
 15 board being recycled back into a new ceiling
 board. Broke, in particular, has fine particulate
 matter in it and this fine particulate matter will
 affect the board's porosity. Listed below are
 two board structures referred to as Formula 1
 20 and Formula 2. Both boards have the same
 material composition as that set out above for
 board formulation. However, in Formula 2,
 27.5 percent of the ingredients is provided by
 broke. In Formula 1, broke amounts to only
 25 20.0 percent of the ingredients provided, and
 such broke was processed to remove dust
 particles and, therefore, Formula 1 has less
 fine particulate matter. Considering the two
 products described above, their acoustical rat-
 30 ings are as follows:

	<i>Cgs Rayls</i>	<i>NRC (4 Freq. Avg.)</i>
Formula 1	1220	0.54
Formula 2	2280	0.42

35 Sound absorption is dependent on the poro-
 sity of the board formulation and on the
 amount of surface area exposed to the sound
 source. When comparing a perforated pattern
 40 to a rilled pattern, both products have vertical
 surfaces which will affect the acoustical rating
 and the horizontal surfaces of both patterns
 will have minimal affect upon the acoustical
 rating. The porosity of the board must give an
 45 air flow resistance (AFR) of approximately
 1200 cgs rayls or less. As can be seen in the
 above formula 1—Formula 2 examples, when
 a product has the 1220 cgs rayls rating, it
 can achieve an NRC of 0.54 which is an
 50 acceptable rating to permit one to call the
 product an acoustical product. When the air
 flow resistance increases as in Formula 2, the
 NRC goes down and the product shown in
 Formula 2 is not considered an effective
 55 acoustical product.

While many conventional mineral fibre
 board formulations, when perforated in a nor-
 mal manner, will provide an NRC in the
 0.55-0.65 range, these formulations were
 60 found to produce an essentially non-acoustical
 product when rilled only. Consequently, the
 rilling alone does not contribute the desired
 acoustical rating. It is the rilling with the
 desired amount of open vertical surface plus a
 65 certain air flow resistance for the board that

gives the desired combination to produce
 acoustical rilled ceiling board.

CLAIMS

- 70 1. An acoustical ceiling board comprising:
 a mineral fibre board structure having a poro-
 sity such that the board will have an air flow
 resistance of approximately 1200 cgs rayls or
 less, having a number of grooves cut in one
 75 face of the board, the grooves having side
 walls perpendicular to the plane of said one
 surface; the said side walls of the said grooves
 being of such a number and size that their
 total area is at least 0.35 of the surface area
 80 of the board.
2. An acoustical ceiling board as claimed
 in claim 1, wherein the grooves of the pattern
 are parallel to each other.
3. An acoustical ceiling board as claimed
 85 in claim 2, wherein the grooves cut in the
 ceiling board are about 6.35 mm wide and
 about 3.2 mm deep and are spaced about 9.5
 mm apart.
4. An acoustical ceiling board as claimed
 90 in any one of claims 1 to 3, wherein the
 horizontal surface of the said face of the
 ceiling board in the plane of the face or
 parallel to the plane of the face are smooth
 and untextured on their surfaces and the side
 95 walls of the said grooves of the ceiling board
 are perpendicular to the said smooth untex-
 tured surfaces.
5. An acoustical ceiling board substantially
 as hereinbefore described with reference to,
 100 and as shown in, the accompanying drawing.

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